



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB877528-4-1

Job Sheet 170017



Part No: RB877528-4-1

Job Qty: 4 ea

Part Name: Shaft

5ea



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/8/18

Job Tracking No:

Due Date: 1/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		12/25/17	0.00	0.00	Start Up Machining-1		SL 18-1-10
110	CNC Lathe	4 pcs		12/26/17	0.00	2.67	MORI SL-154		SL
120	QC	4 pcs		12/26/17	0.00	0.00	QC2 Machining-4		SL
130	QC	4 pcs		12/26/17	0.00	0.00	QC8 Machining-4		SL 18-01-11
140	QC	4 pcs		12/26/17	0.00	0.00	QC5		SL 18-01-11
150	Outsource	4 pcs		1/10/18			GRO002-VC		AT 18/02/09
160	Packaging	4 pcs		1/10/18	0.00	0.00	Packaging2		AT 18/02/09
170	QC	4 pcs		1/10/18	0.00	0.00	QC5		AT 18/02/09
180	Packaging	4 pcs		1/10/18	0.00	0.00	Packaging3-1		AT 18/02/09
190	QC21-SA	4 Ea		1/10/18	0.00	0.00	QC21		FEB 13 2018

Part Op 110 - 1-Machine as per Folio: FB611 FOLIO REV: AA DWG REV: 3 2-DEBURR
Descriptions: 150 - -Issue P/O to Groupe Altech: PO 38804 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of
Conformity is required

DAS
13
9-89

JAN 17 2018

FEB 1 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MT-1144-R0.750	1	17	0	0
	FF000024	1.95	5030870		

Part Specifications

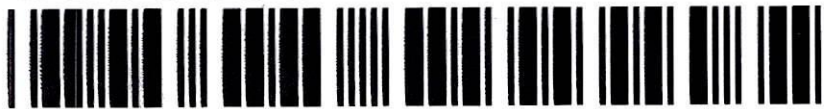
Specifications could not be found.

Plex 1/8/18 9:15 AM Dart.lajeunesse.marie

4.75NS

DART
AEROSPACE
S030885

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Shaft

PART NO: RB877528-4-1

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 01/10/18

Job No: 170017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

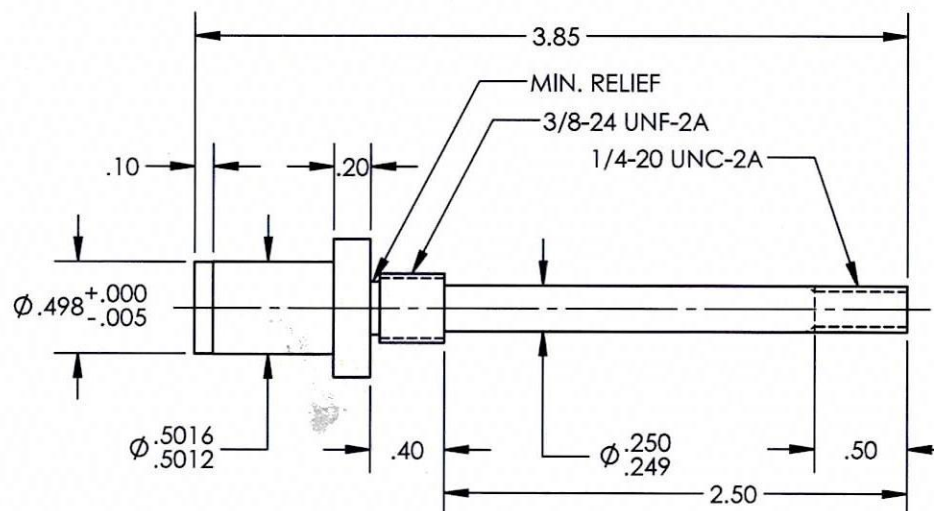
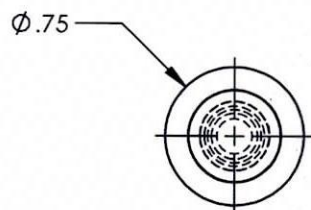
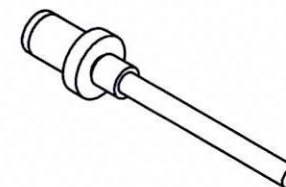
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐																								
Misidentified ☐	Past Due ☐	OTHER :																							

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3	15-0104	-1 CH'D DIM WAS Ø.501 IS Ø.5012-.5016. ADDED DIM .10. DELETED TAPER. DELETED DIM 2.000. ADDED DIM 2.50. ADDED MIN. RELIEF.	5/13/2015	DPD	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170017 MC
18-01-08

(-1)
SHAFT

DART AEROSPACE	
TITLE DAMPER BEARING TOOL KIT	
DWG NO. RB877528-4-1	REV 3
MAT'L STRESSPROOF	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH BLACK OXIDE
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	MD 500D
SCALE 1:1	DATE 6/28/2000
SHEET 2 OF 9	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

PURCHASE ORDER

PO038806

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO038806

PO Date: 1/17/18

Due Date: 1/31/18

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Baker, Diane Phone:
dbaker@dartaero.com

*Revised \$
P/O*

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

				Items						
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	169661	RBW6405G08832-3G-01	Install Rod -Issue P/O to Groupe Altech; P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required	Firmed	1/26/18	4 pcs	0 pcs	4 pcs	\$22.50/pcs	\$90.00
						✓ 4x			AT 18/01/29	
2	169786	SK145-0115-20	Clamp Bar ISSUE P/O: _____ PASSIVATE AS PER DWG ACCORDANCE WITH ASTM A967 C OF C IS REQUIRED	Firmed	1/26/18	5 pcs	0 pcs	5 pcs	\$20.00/pcs	\$100.00
						✓ 5x			AT 18/02/09	
3	170020	RB877528-4-17	R & I Adapter -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	1/26/18	5 pcs	0 pcs	5 pcs	\$10.91/pcs	\$54.55
						✓ 5x			AT 18/02/09	
4	170017	RB877528-4-1	Shaft -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	1/26/18	5 pcs	0 pcs	5 pcs	\$10.91/pcs	\$54.55
						✓ 5x			AT 18/02/09	
5	169098	RB6795635-2	Socket Assembly -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$10.91/pcs	\$10.91
						✓ 1x			AT 18/02/09	



Certificat de Conformité / Certificate of Compliance

(005929-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

005929 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
25-Jan-2018		Curtis Anderson		038806					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
1	RBW6405G08832-3G-01 Rev.	INSTALL ROD 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] SPÉC: ASTM B633 TYPE 1 SC2 ***	ZINC	4	4	0	0	0	
			CH						
2	SK145-0115-20 Rev.	SK145-0115-20 01 -PASSIVATION- #3 [PASSIVATION #3] SPÉC: ASTM A967 C OF C *** SPÉC: AS PER DRAWING ***	PASSIVATION	5	5	0	0	0	
			CH						
3	RB877528-4-17 Rev.	R & I ADAPTER 01 -OXIDE BLACK [OXIDE BLACK] SPÉC: MIL-C-13924C CLASS 1 ***	OXIDE-BLACK	5	5	0	0	0	
			CH						
4	RB877528-4-1 Rev.	SHAFT 01 -OXIDE BLACK [OXIDE BLACK] SPÉC: MIL-C-13924C CLASS 1 ***	OXIDE-BLACK	5	5	0	0	0	
			CH						
5	RB6795635-1 Rev.	RB6795635-1 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C: CLASS 1 ***	BLACK-OXIDE	1	1	0	0	0	
			CH						
6	646.3912 Rev.	646.3912 CAD PLATE PER QQ-P-416 TYPE 2 CLASS 2 ,CL2	CADMIUM	30	30	0	0	0	
			CH						
7	646.3913 Rev.	646.3913 CAD PLATE PER QQ-P-416 TYPE 2 CLASS 2 ,CL2	CADMIUM	5	5	0	0	0	
			CH						
8	646.3911 Rev.	646.3911 CAD PLATE PER QQ-P-416 TYPE 2 CLASS 2 ,CL2	CADMIUM	9	9	0	0	0	
			CH						
9	646.3910 SHIM Rev.	646.3910 SHIM CAD PLATE PER QQ-P-416 TYPE 2 CLASS 2 ,CL2	CADMIUM	27	27	0	0	0	
			CH						

Yul



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 Tel.: 613-632-5200 Fax.:

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 CANADA
 BUYER:

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25-Jan-2018		Curtis Anderson				038806				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)			CATG. U/M	Quantités / Quantities				
Job # / Ref #						Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements
 Our financial and legal responsibility will not be higher than the amount of invoice.